\	*114335*				Page 1
Accept	*N90	<u> </u>	N 0*	Setup Star	*NS1*
		•		Stop	*NS2*
12	Cust Iter	m ID:			10(1)
e: <u>14-03-05</u> Tooli	ng:	Date:	<u> </u>		~IVH ! ^
e:SPC ((Y/N):	Date:		Stop	" *NR2*
	≜ '		-	Reject Qty	Reject Insp. Number Stamp
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3564 Dwg Rev: D P	rog Rev: 2-				
FAI/FAIB 0.00					•7
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ek 0.00	07				
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	12 *12* *12* E: 1403-05 Tooling SPC (Set Ru 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0.00	*12* *12* Cust Ite Custome e: \(\frac{14}{2} \) \(\frac{1}{2} \) SPC (Y/N): Set Up/ Run Hours 0.00 0.00 D Prog Rev: \(\frac{1}{2} \) FAI/FAIB 0.00 0.00 0.00 DAS AS AS AS AS A A A A A A A A A A A	Accept	Accept	Accept

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						Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	0					Scrap			Machining	Small Fab			d. Eng. Coor.	-	Quality
						Use-as-is		Therr	noforming	Finishing	_ '	Rec/Stor	re/Packaging	_	Other
NCR N	lo					Suspected Unapproved]		Large Fab	Composite			Supplier	<u> </u>	
Root					Desci	ription of work order update		Initial	Act	tion	S	ign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
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Doc/Data	_														-
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}	Cu		k) vibbie	/ wave	-	Contamination	┝	1	ion Incomplete/Ur	·		t Lost/Mi t Moved	-	\vdash	Weld
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ŀ	\dashv		Strip in	Tube	-	Drawing	\vdash	Misrea	•	L		/EI LUSS/	ange	_	Toulei
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-			equence		-	Finish	-	4	Calibration					—	<u>-</u>
ļ		_	ist in Tub	e		Fit/Function	H	1	Sequence						

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Work Orde March-04-14 3:		4335	,	*1	14335*						Page 2	· · · · · · · · · · · · · · · · · · ·
Revision ID:	D3564-13 Stainless Steel	Wearpad Fwd		Accept	*N900	04010	// *	Setup St	tart top	*N!	31* 32*	
Start Date: Required Date: Reference:	04/03/2014 04/03/2014	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *	[Cust Item I Customer:	D:						
Approvals:		n:	Date:	Tooling: SPC (Y/N):		nte:	_		tart top		२1* २2*	
Sequence ID/ Work Center II 130 *130* Brake NC)	Operation Description NC BRAKE Memo		Set Up/ Run Hour 0.00		Tool # Plan Code	_	Qty		leject lumber	Insp. Stamp	llos/29
140 *1 4 \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		Deburr if ne QC5- Inspect part compl Memo	ecessaryForm on Brake a) 2	ng Jigs DT 8179 AS 27 389	9.89	<u> </u>					
150 *150* Powdercoat Powder Coating		Grey Sandtex(Ref:4.3.5. Memo START TIM	D∂D. 1:2	0.00 0.00 OVEN TEMPERA	TŲRE:		20	φ_	<i> </i> -1-	<u>-3-2</u> i	5	DAS 34 9-89

DQA:		Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:				_			W	ork Order up	date only	
Work Orde	۵r۰					DISPOSITION			AGAINST	DE	PARTMENT,	/PROCESS	
Work Orac	•				-	Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	$\overline{}$	Pro	d. Eng. Coor.	Quality
	•			·-·		Use-as-is			noforming Finishing		ł	re/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite		,	Supplier	-
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Root					Desci	ription of work order update	I	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Material													
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Landi	ng G	ear				General					-		
		Bending				Bend	L	Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
:		Cracks				Broken/Damage/Defect		Hardwa	re	L	Part Incorred	ct _	Temperature/Cure
		Crimp/Kir	nk/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	
		Heat Trea	nt			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misread	i				
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of (Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

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Work Orde March-04-14 3:	er ID 114335 02:24 PM	·	*112	1335*		Page 3
Revision ID:	D3564-13 Stainless Steel Wearpad Fwd		Accept	*N90004010	Setup Start Stop	*NS1* *NS2*
	04/03/2014 Start Qty: 1	1 7		Cust Item ID: Customer:		14.72
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*
Sequence ID/ Work Center ID 160	Operation Description QC3- Inspect Par	a Finish	Set Up/ Run Hours	Tool ID Tool # Plan Code		eject Insp. umber Stamp
1 AN QC Quality Control	QC3- Inspect Par		0.00		22 🔏	14/03/25
¹⁷⁰ *17∩*	Identify as per dv	wg & Stock Location (2001)	0.00		v22 f	Il Hostra
Packaging Packaging	Мет	no	0.00		X CV(<u> </u>
180	QC21- Final Insp	pection - Work Order Release	0.00		· - 1/1. or	\7 7 (
*1 A O * QC Quality Control	Mer	mo	0.00		MUJ 14-0	7800
Quanty Control					WC	5 1403-26

DQA:			Date:						_				DART
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UI		/ork Order up	odate only	AEROSPACE
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Work Orde	er: _						,				` ¬	·	, ,
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	NO					Scrap			Machining	Small Fab	_	d. Eng. Coor.	Quality
NICD A						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	NO					Suspected Unapproved	J		Large Fab	Composite		Supplier	
Root					Desci	ription of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
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Landi	ng Ge	ear				General		-			_		_
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:		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure
	\square°	rimp/Kin	k/Ripple	/Wave		Burrs	L	Inspect	on Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
	\vdash	uffs				Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
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	_	nspection	•	Tube		Drawing		Misread	1	_			
		∕Iarks/Ch				Drill Holes		Off-set		-			
	╚	urning S	equence			Finish		Out of (Calibration				
	Ιlν	Vave/Tw	ist in Tub	e	l	Fit/Function	1	Out of	Sequence				

Page 1

Work Order ID: 114335

114335

Parent Item:

D3564-13

D3564-13

Parent Item Name: Stainless Steel Wearpad Fwd

Start Date: 04/03/2014

Required Date: 04/03/2014

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	194.1370	0.222	3			
M304S16	SGA								**	E	\sim \sim \sim	4-3-/	4

M304S16GA

304/316 Sheet .063

Locati	<u>on</u>	Loc Qty	Loc Code	
MAT0	20	194.137		
	M126915	1.487		
	M127821	128.33		
	M128054	64.32		
	m 128423	× 5.5		

DQA:			Date:							_					7	
QA Closed:			Date:			WORK OF	RDER NON-	-CC	ONFO	RMANCE / U	PDATE		ork Ordor un	udata anku 1		AEROSPACE
QA Closed.			Date.					\neg				VVC	ork Order up	date only		
Work Orde	er:					DISPO	SITION				AGAINST	DE	PARTMENT	PROCESS		
					_		Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	۱o						Scrap		!	Machining	Small Fab		Pro	d. Eng. Coor.		Quality
							Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	No					Suspected Un	approved			Large Fab	Composite			Supplier		
Root					Desci	ription of work o	order update		nitial	Ac	tion		Sign &		П	
Cause		Date	Step	Qty		or non-conforr	•	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
Design																
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	\vdash	Bending			ļ	Bend		$ldsymbol{ld}}}}}}$		'rogram		-	Outside Dim			Pressure/Forced
	Н	Centre No	ot Concer	ntric		BOM/Route			Grain			Ш	Over/Under	tolerance	-	Set-up
	-	Cracks				Broken/Damag	e/Defect		Hardwa			\vdash	Part Incorred	-	-	Temperature/Cure
	\vdash	Crimp/Kir	nk/Ripple,	/Wave		Burrs		_	•	ion Incomplete/U	•	Ш	Part Lost/Mi	ssing	Ш	Weld
	_	Cuffs			<u> </u>	Contamination				ions Incomplete/	Unclear	\vdash	Part Moved			Wrong Stock Pulled
	_	Crushing			<u> </u>	Countersink		<u> </u>		ned/off center		-	Positioned V			
	_	Heat Trea				Cut Too Short		$oxed{oxed}$	Mislabe				Power Loss/	Surge		Other
	$\overline{}$	Inspection	· · · · · · · · · · · · · · · · · · ·	Tube	<u> </u>	Drawing		-	Misread	d				· · · · · · · · · · · · · · · · · · ·		
	$\overline{}$	Marks/Ch			<u> </u>	Drill Holes		L	Off-set							
	_	Turning S				Finish		_	l	Calibration						
	ιlv	Wave/Tw	ist in Tub	e		Fit/Function		1 .	Out of	Seguence						

DART AEROSPACE LTD	Work Order:	114332
Description: Wearshoe	Part Number:	D3564-13
Inspection Dwg: D3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.00	+/-0.030	7.005			JKMOS	
2.432	+/-0.010	7.441			- O.J.W.	
3.227	+/-0.010	3.275				
3.500	+/-0.010	3.504	1			
0.300 x 0.300	+/-0.010	0.302 x 0.362	/			
Ø0.188	+0.005/-0.001	6.189	/			
0.063	+/-0.010	0.060				
		i l			1	

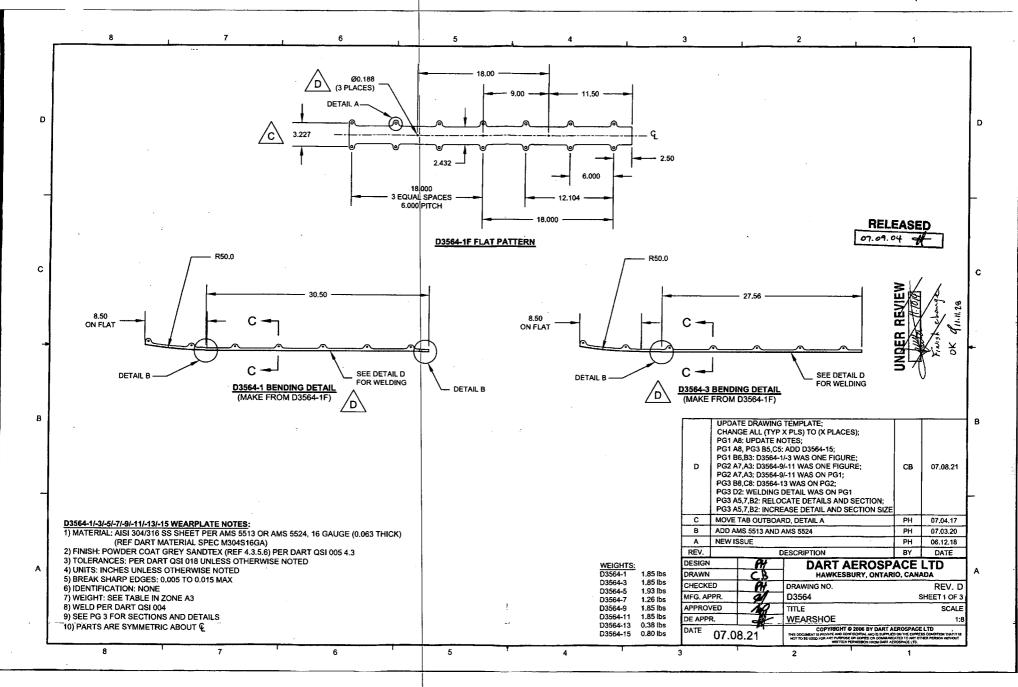
Measured by: Audited by: 27 Prototype Approval: N/A

Date: 14-3-14

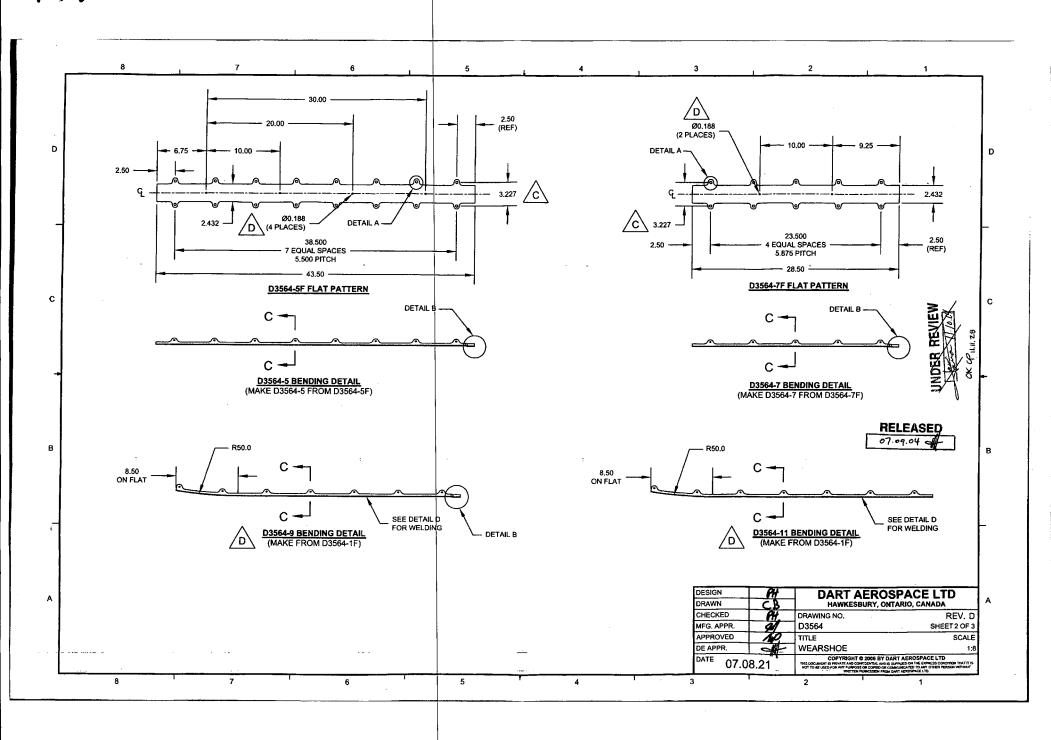
Date: 14/3/7

Date: N/A

Rev	Date	Change	Revised by	Approved
Α	07.04.02	New Issue	KJ/JLM	
В	07.07.18	Dimensions updated per Dwg Rev. C	KJ/JLM , ,	
С	08.02.28	Dwg Rev updated	KJ/DD ox	77
С	08.02.28		KJ/DD	



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